

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026218**Date Inspected:** 25-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Watson Bowman Acme Corp.**Location:** Buffalo, NY**CWI Name:** Greg Ross**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Seismic Joint Hinge A**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Dustyn Broening was present at the Watson Bowman Acme Corporation (WABO) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A for the San Francisco Oakland Bay Bridge (SFOBB) project.

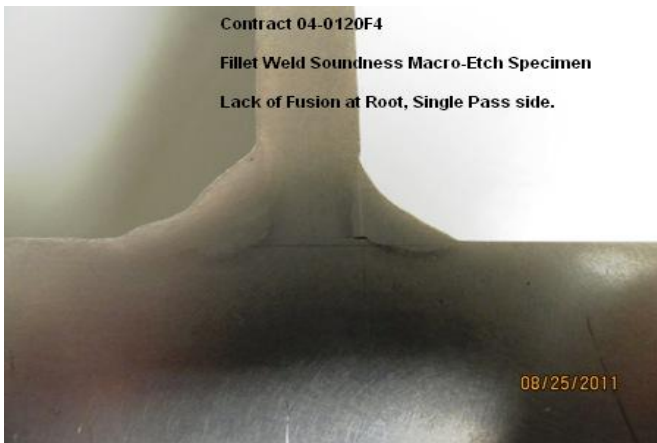
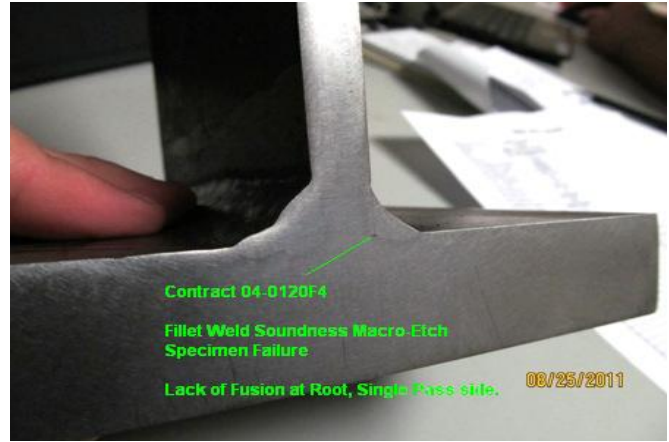
This Quality Assurance Inspector (QAI) met with Watson Bowman Acme Corporation (WBA) Quality Control Manager (QCM) Mr. Gregory Ross, Quality Control Supervisor (QCS) John Miller and (KTA-Tator, American Welding Society Certified Welding inspector (AWS CWI) Mr. John Gotwald, inspector on the day shift.

This QAI observed certified macro-etched fillet weld soundness test coupon. Test results indicate a lack of fusion at the root on the single pass side of the coupon. QCM relayed that he wishes to do a retest on 8/26/11.

This QAI observed certified welder Jayson Gray (welder ID#J) using the FCAW process (dual shield, 100%CO2), filler metal TM-811N1, to weld CJP welds on SEI112667CA2 5, SEI112667CA2 6, (2 assemblies) of (24ea required) Channel Assemblies are being worked on at this time. Welds are being performed on the End Plate to Bottom Plate, Top Plate and Back Plate connections. All welding was being performed in the 1G position and are being installed within the parameters of approved WPS #FCAW-13. See attached photos.

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Summary of Conversations:

Other basic communication was performed between the QAI and the QCM.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Broening,Dustyn	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
